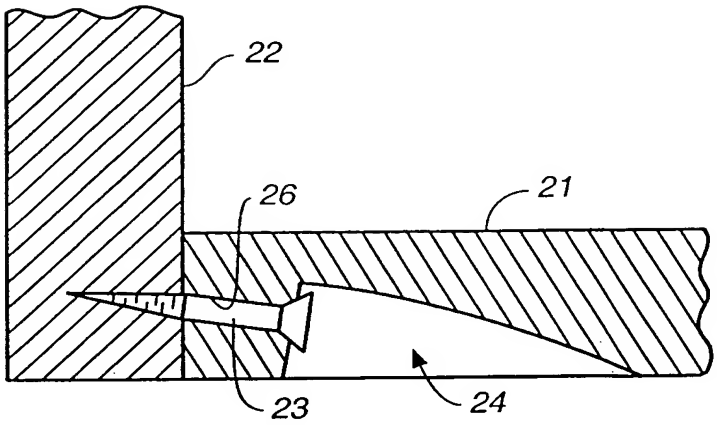


FIG._1
(PRIOR ART)

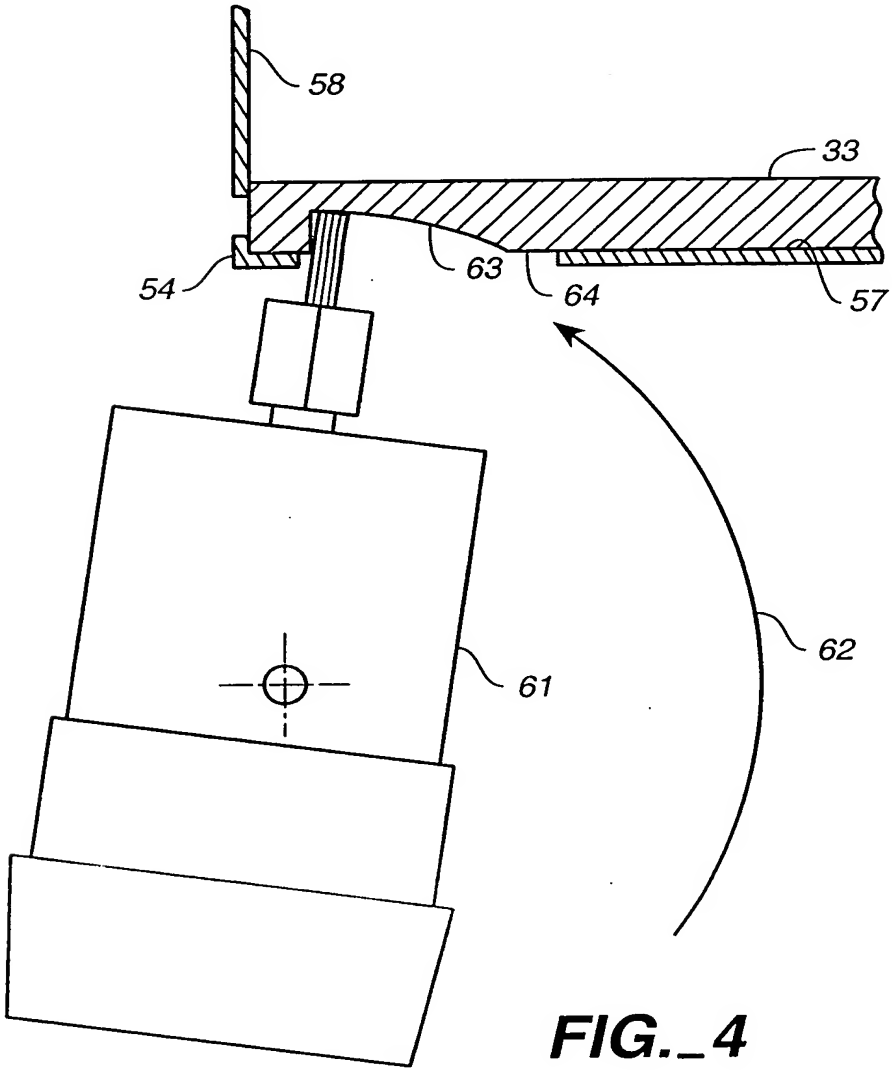


FIG._4

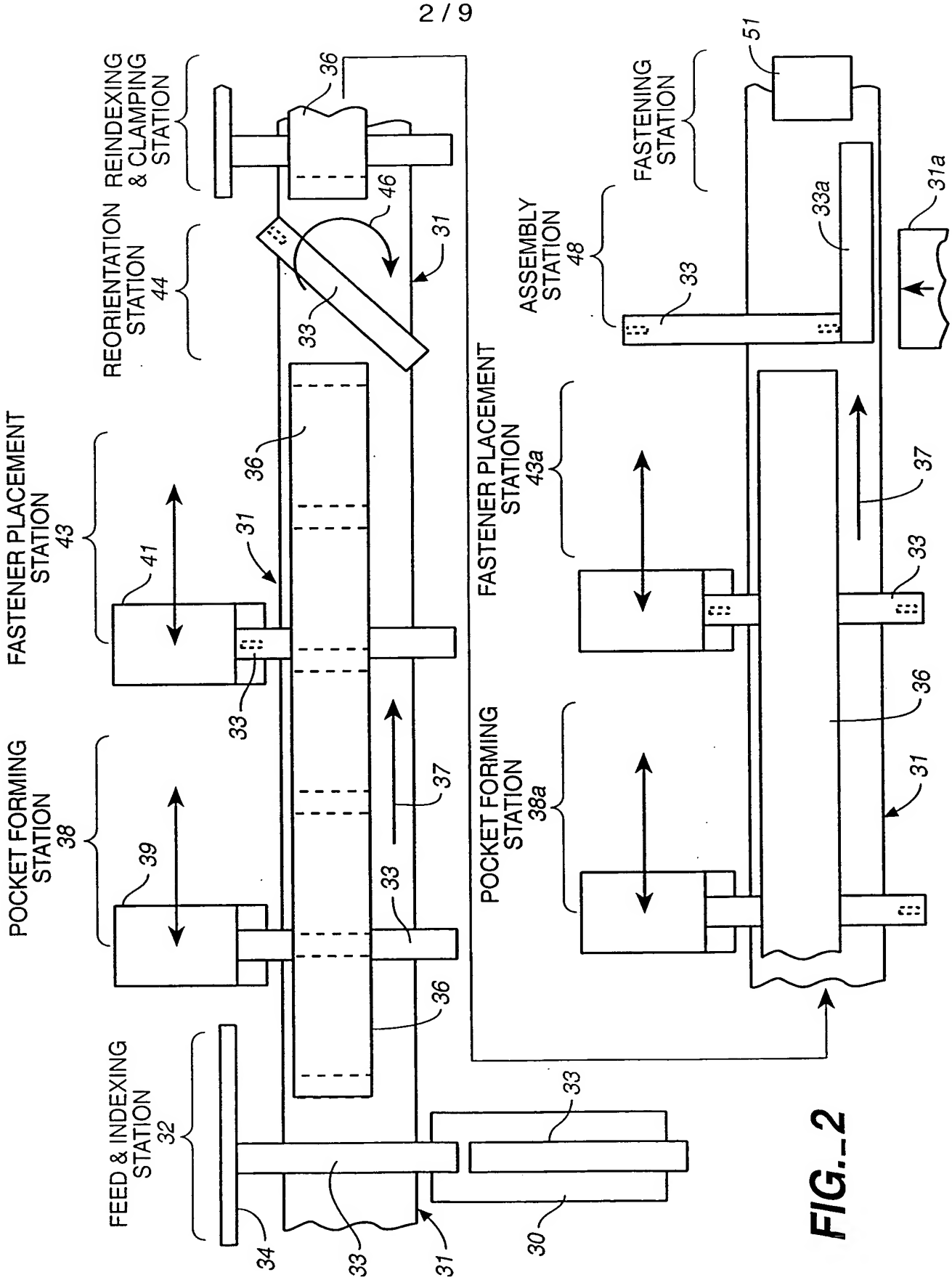

FEED & INDEXING STATION
32
POCKET FORMING STATION
38
FASTENER PLACEMENT STATION
43
REORIENTATION STATION
44
REINDEXING & CLAMPING STATION
POCKET FORMING STATION
38a
FASTENER PLACEMENT STATION
43a
ASSEMBLY STATION
48
FASTENING STATION
51
30
31
31a
33
33a
34
36
37
39
41
46

FIG._2

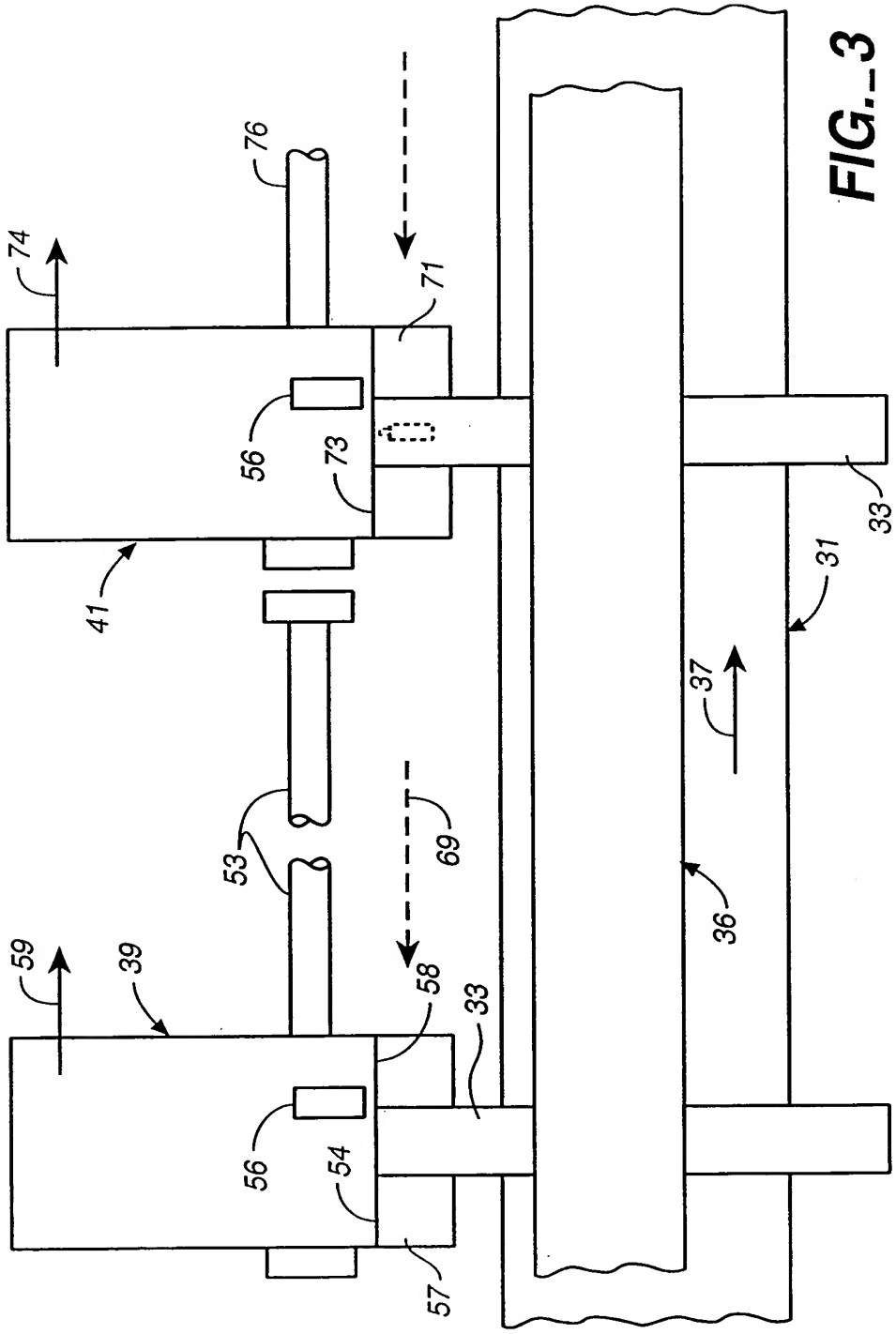
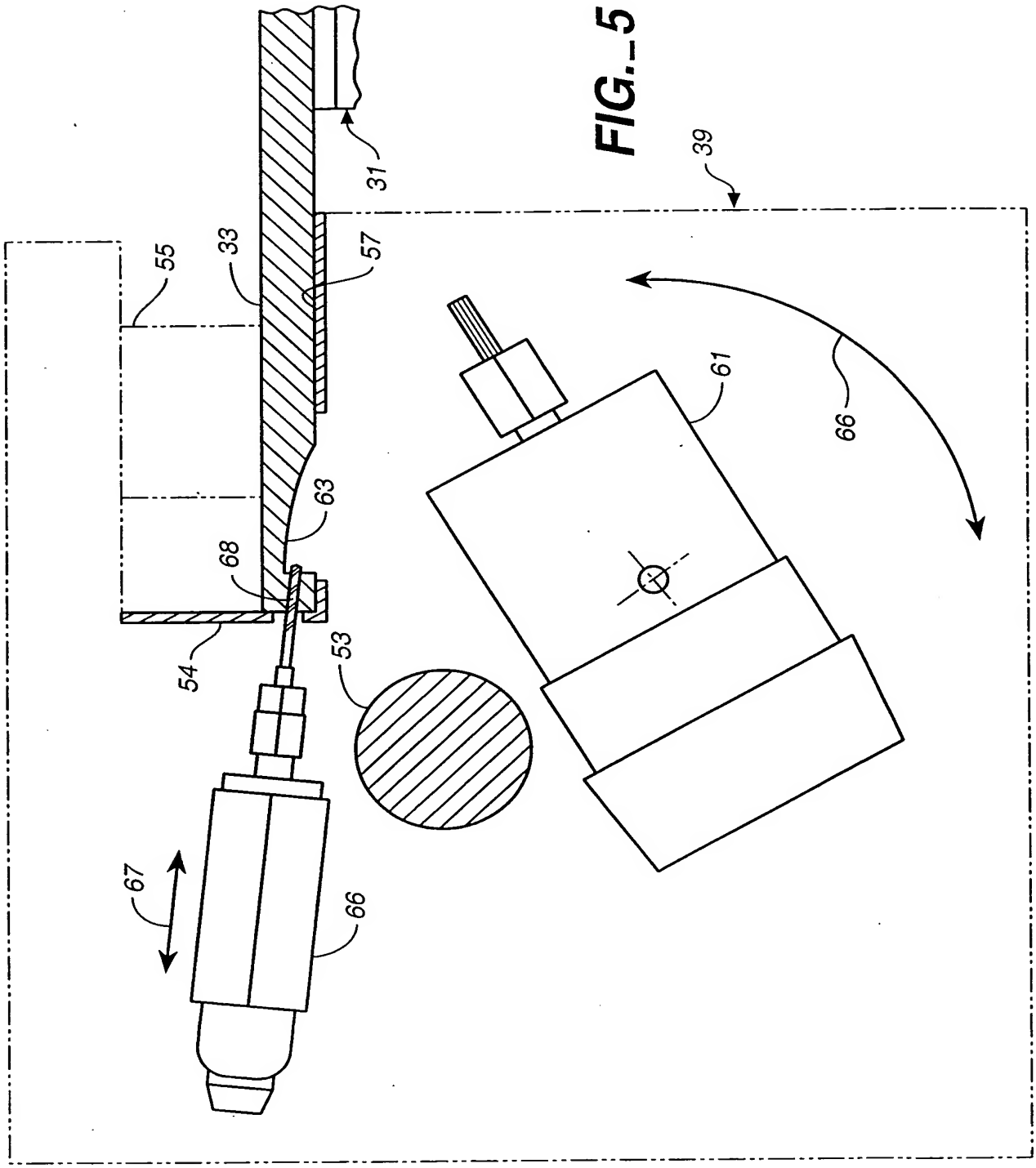


FIG._3

FIG._5



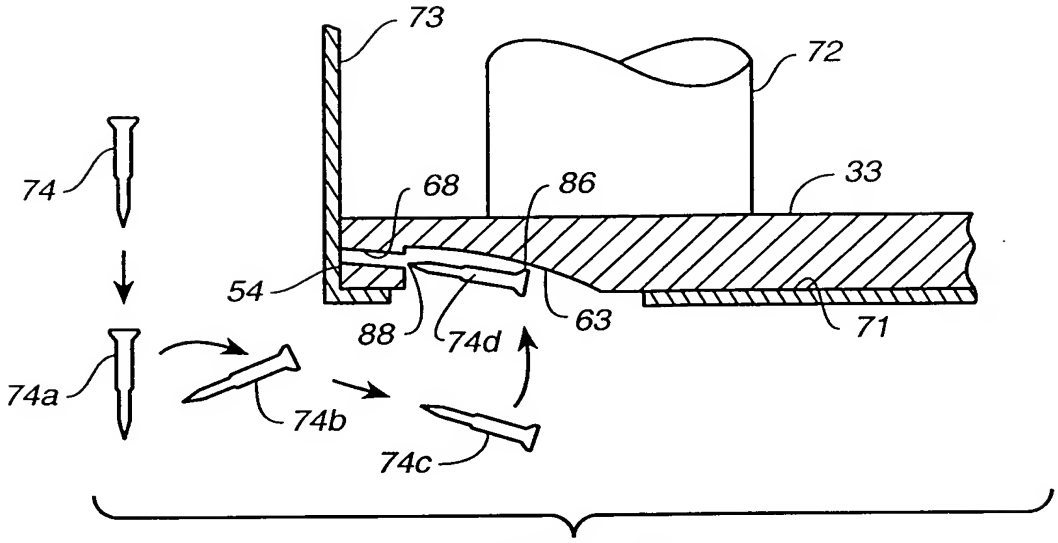

73
72
74
68
86
33
54
88
74d
63
71
74a
74b
74c

FIG._6

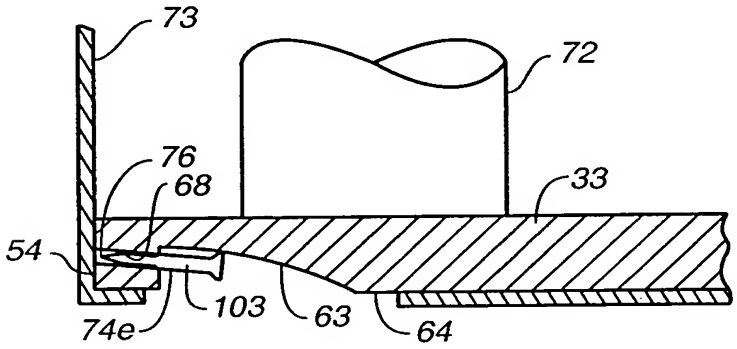

73
72
76
68
33
54
74e
103
63
64

FIG._7

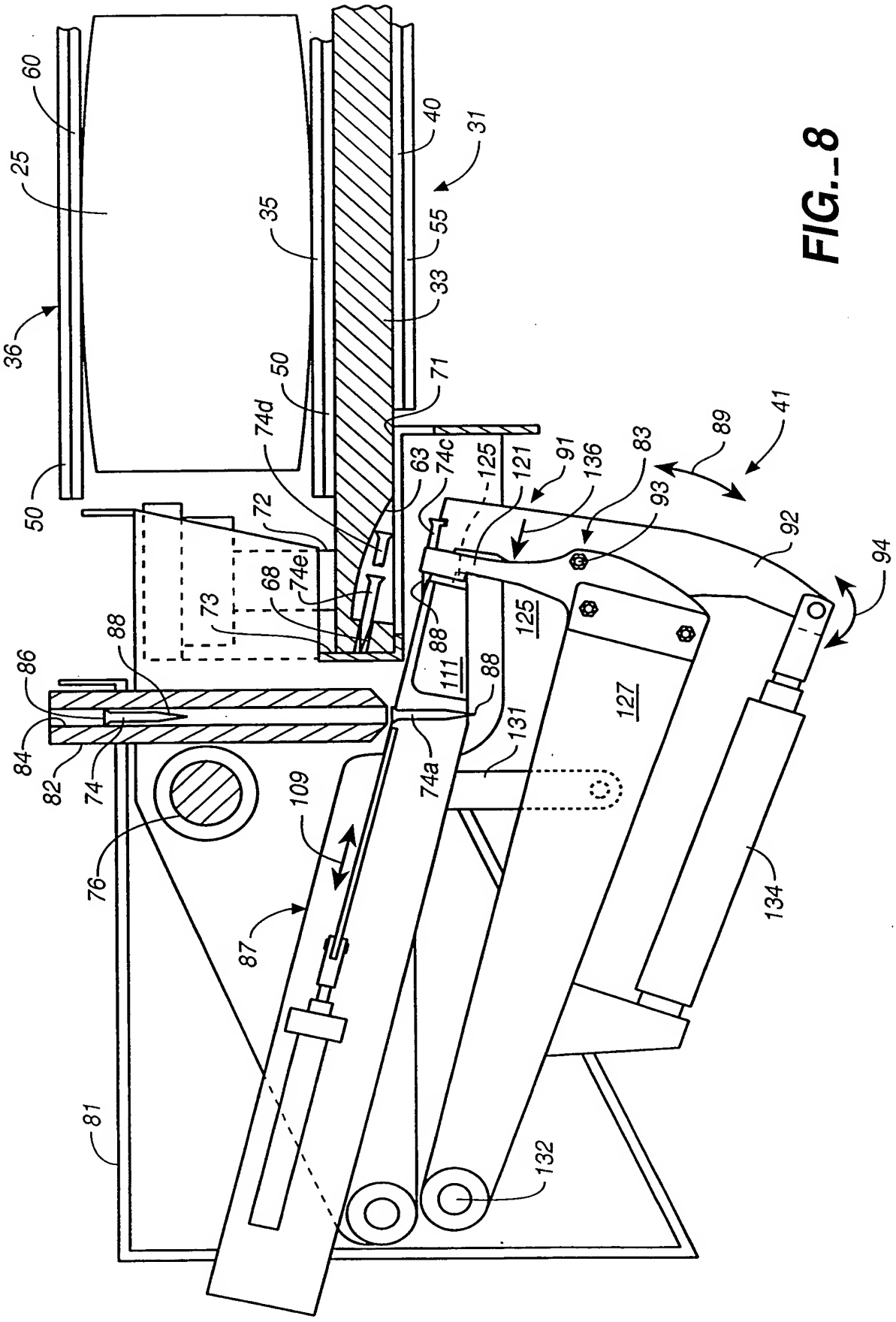

60
25
40
31
35
55
33
36
50
71
74d
63
74c
125
121
91
136
83
89
41
72
93
92
94
68
74e
73
88
111
131
74a
109
76
87
81
132
134
127
86
84
82
74

FIG._8

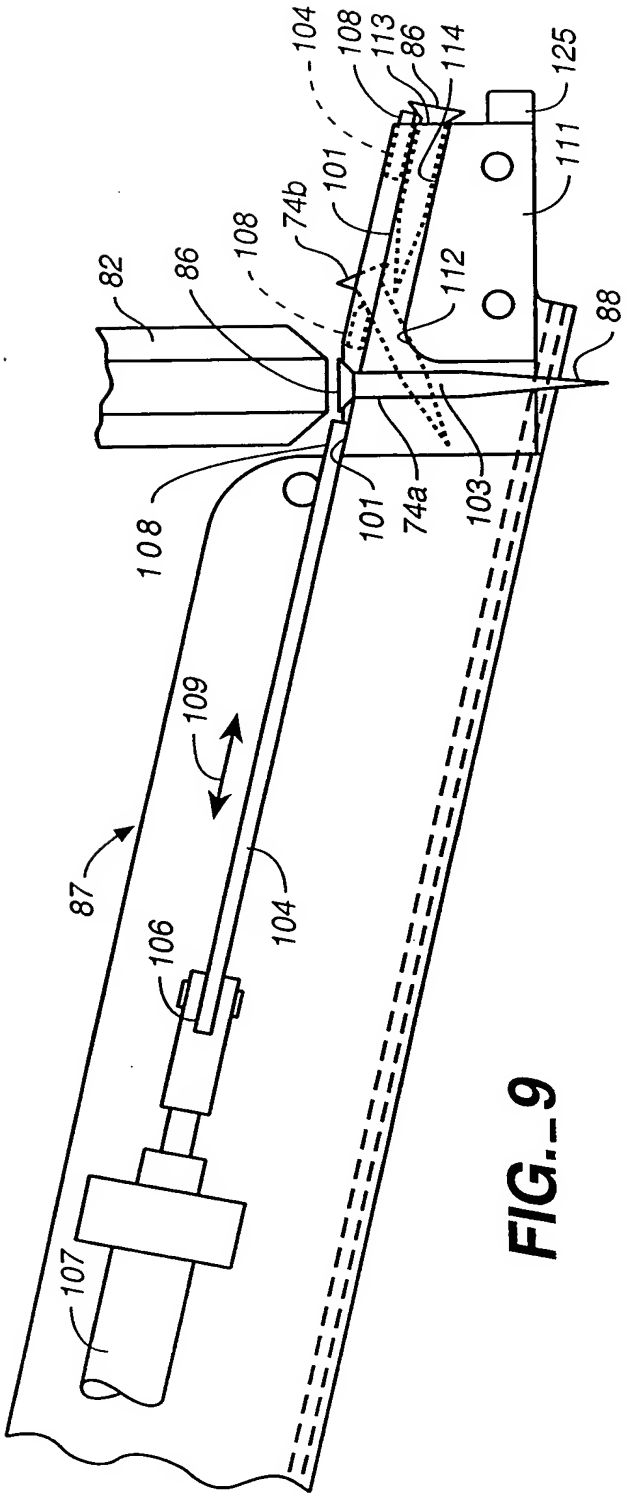

104
108
113
86
114
125
111
101
74b
108
82
86
112
88
108
101
74a
103
109
87
104
106
107

FIG._9

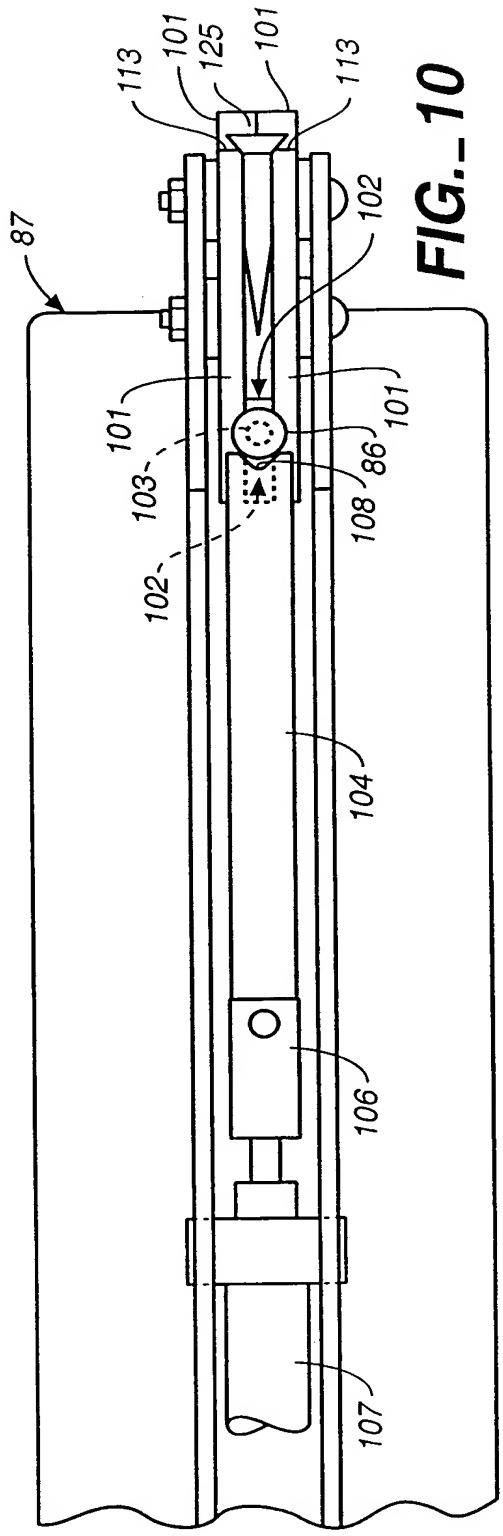

113
101
125
101
113
87
102
101
101
103
86
108
102
104
106
107

FIG._10

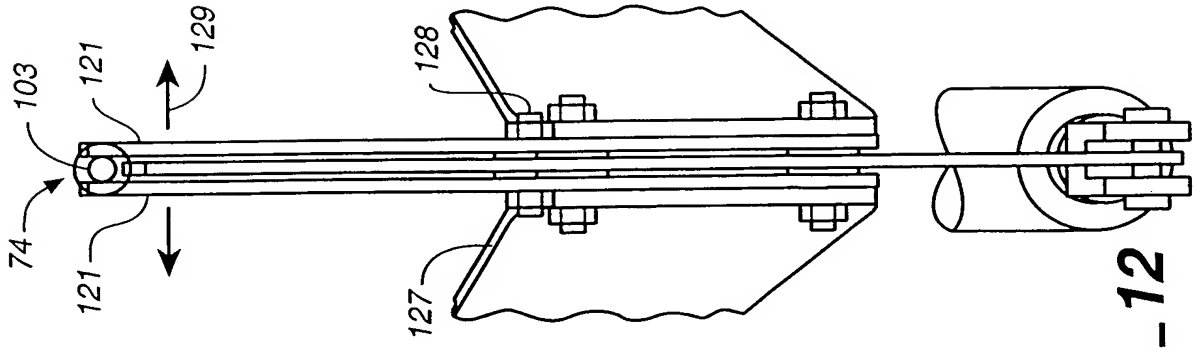

103
121
129
128
74
121
127

FIG._12

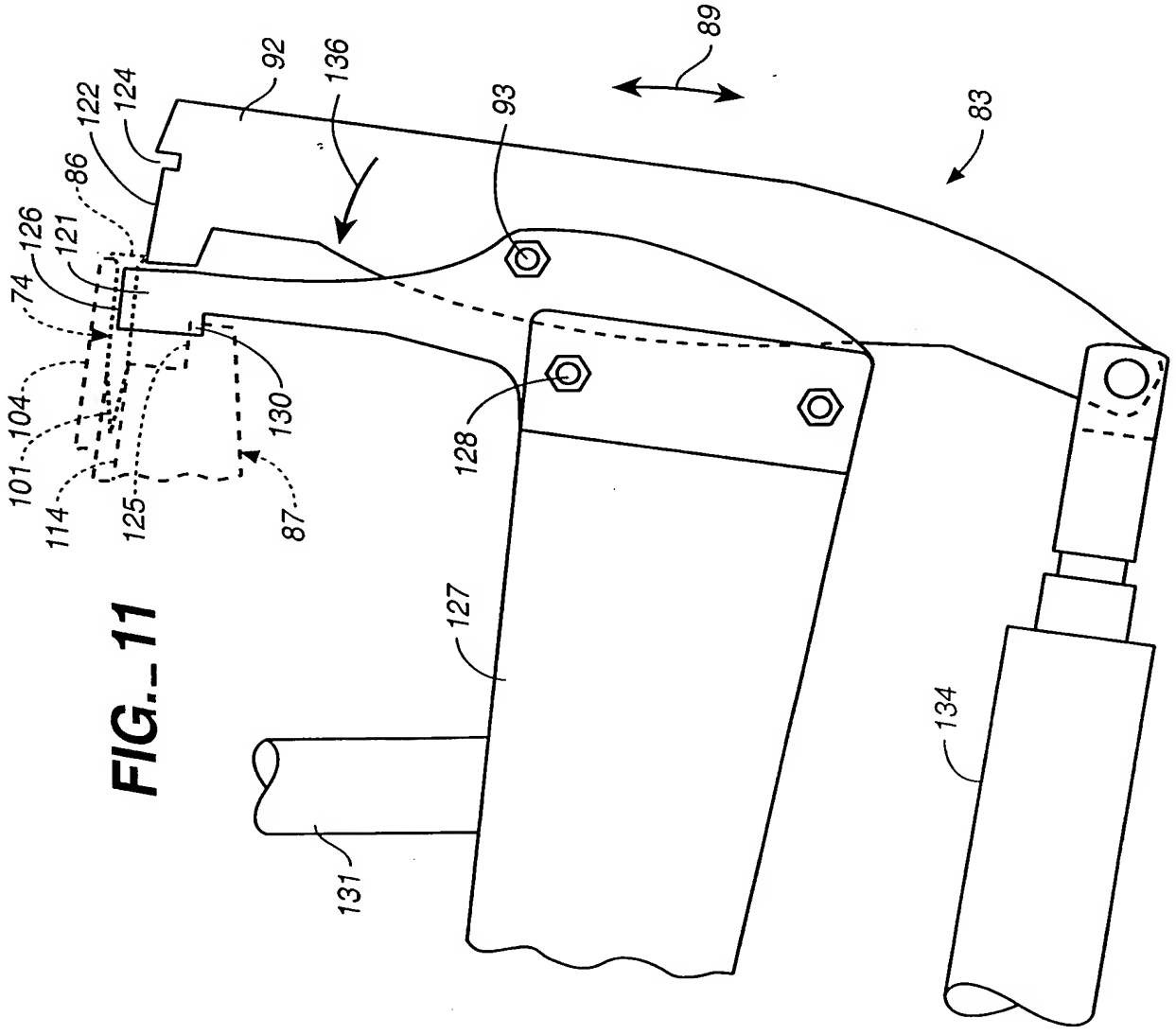

89
92
136
93
83
122
124
86
126
121
74
104
101
114
125
130
87
128
127
131
134

FIG._11

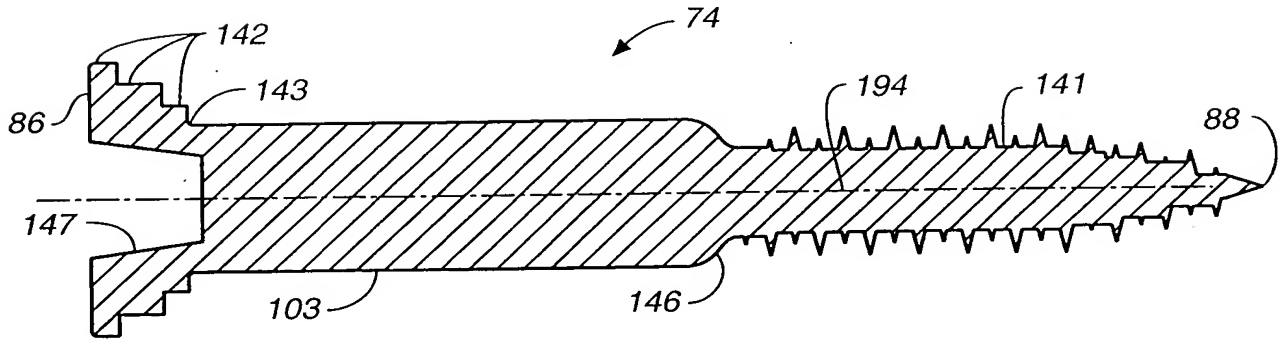


FIG._13

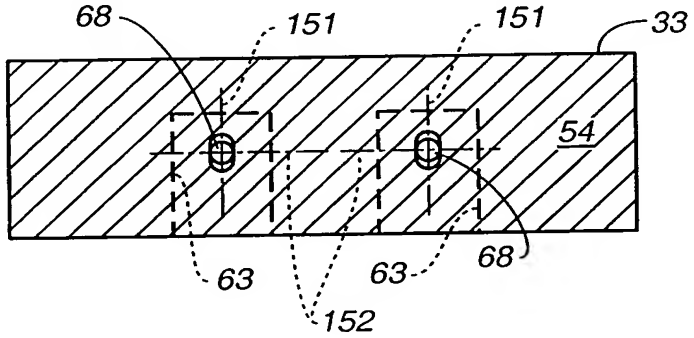


FIG._14